

Date: Thursday, 03/07/2008 10:37:38 AM
 User: Melanie Fauteux

Process Sheet

| | | | |
|-------------------------|---|--------------------|-----------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | HANDLE WELDMENT |
| Job Number : | 40211 | | |
| Estimate Number : | 10333 | | |
| P.O. Number : | | Part Number : | D2530 |
| This Issue : | 03/07/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D2530 REV B |
| First Issue : | 11 | Project Number : | N/A |
| Previous Run : | 37853 | Drawing Revision : | B |
| | Type : SMALL /MED FAB | Material : | |
| Written By : | | Due Date : | 10/07/2008 |
| Checked & Approved By : | Qty: 19 / 20 Um: Each | | |
| Comment : | Est Rev:E Removed Purchasing 05-11-07 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 3.0602 f(s)/Unit Total: 61.2045 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: M108498



| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1



1-Cut to length as per Dwg D2536

2-Deburr

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP



| | | |
|-----|-------|------------|
| 4.0 | D2534 | Lock Plate |
|-----|-------|------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

| | | | |
|-----|--------|-------------|----------|
| QTY | Part # | Description | Batch |
| 2 | D2534 | Lock Plate | B32620-5 |



| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|






Comment: SMALL & MEDIUM FAB RESOURCE 1



1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|--------|----------|--|---|----------|-----|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 8/7/14 | # 5.0 | only enough D2534 to make 19 D2530. Put one (1) D2536 in stock with B#40211 |  | 08/07/14 | (1) |  |  |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 03/07/2008 10:37:38 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 40211

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soda/14 (19)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

START TIME:

2:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:30pm

08-07-14

(19)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/L 08/07/14

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 204

AS 08/07/15 (19)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16

Job Completion



MF 08-07-16

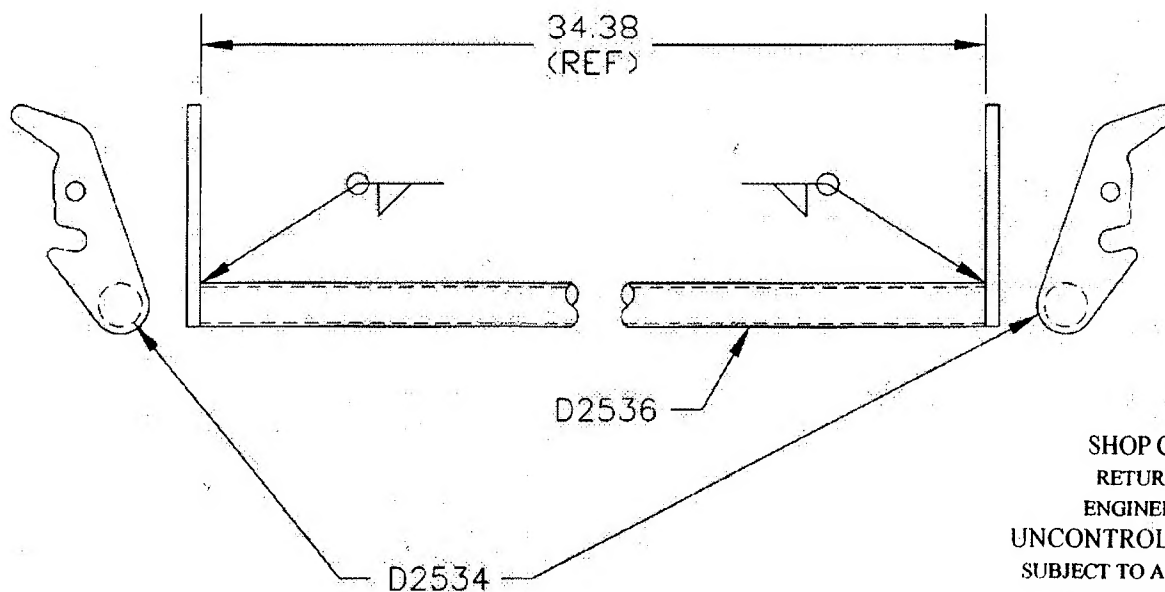


| | | | |
|----------------------------|-----------------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | PH | DRAWING NO. | REV. B |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | D2530 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 04.12.14 | HANDLE WELDMENT | | |
| A | 96.06.18 | NEW ISSUE | |
| B | 04.12.14 | UPDATE NOTES AND DIMENSIONS | |

RELEASED
04.12.16 *[Signature]*

PART LIST -- D2530

| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-----------------|
| X | D2530 | HANDLE WELDMENT |
| 1 | D2536 | HANDLE |
| 2 | D2534 | LOCK PLATE |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40211

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED